Work Order ID 71282

Monday, June 27, 2011 9:13:36 AM

Item ID: D3916-041 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Rib Assembly

Start Date: 6/27/2011 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 6/30/2011 **Req'd Qty:** 6.00 **Customer:**

Reference:

Approvals: **Process Plan:** K **Date:** 11-06-27 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3916	A								
100	Weld per dwg A/R S.S. rod Batch: ~~117885~~ 117884	0.00							
Large Fab	**Memo**	0.00							
Large Fab	1- Cut tube 50" 2- Bend tube with manuel pipe bender as per DT9567 *** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending*** 3- Trim access tube material to finish size as per dwg D3916 4- Drill and chamfer holes as per dwg D3916-1 using DT9605 5- weld bushing as per dwg D3916 6- grind welds flush								
110	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									

GC 11.07.15

AA 11.07.15 (5)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 71282

Monday, June 27, 2011 9:13:36 AM

Item ID: D3916-041 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Rib Assembly

Start Date: 6/27/2011 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 6/30/2011 **Req'd Qty:** 6.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: WA05	0.00							
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11.07.15

11.07.15

11/7/15

MK 11-07-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Monday, June 27, 2011 9:13:54 AM

Work Order ID: 71282

Parent Item: D3916-041

Parent Item Name: Rib Assembly

Start Date: 6/27/2011 **Required Date:** 6/30/2011

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP RevA: New issue DD verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1		Manufactured	No			100	Each	255.0000	7	42	[redacted]		
Bushing													

Location	Loc Qty	Loc Code		
WA	200			
69202	200		29	
WA005	55			
66489	2			
66870	53		13	

RpC 11-07-15

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049		Purchased	No			100	f	252.1792	4.166	26.31158			
304 SQ Tube .75x.75x.049W													

RpC 11-07-15

Location	Loc Qty	Loc Code		
MAT018	228.5777			
117690	63.5286		26.31158	
117775	165.0491			
MAT034	23.6015			
117337	23.6015			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

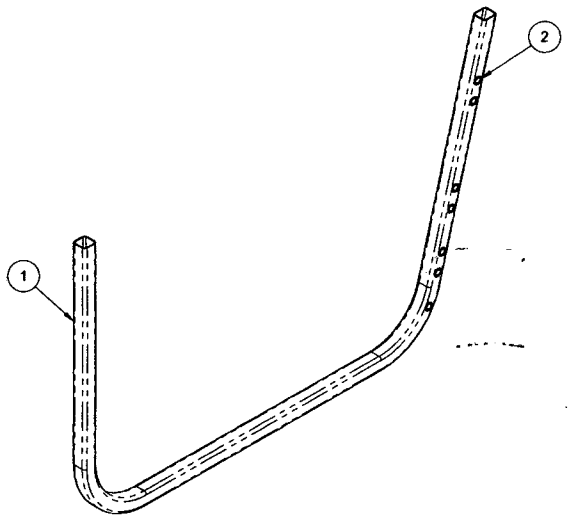
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

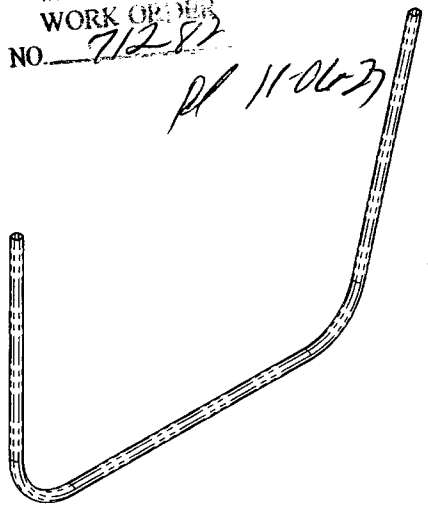
NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71287



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

OK 10.12.21
UNDER REVIEW
10.10
ADDITION OF HOLE + BUSHING ON D3916-041/-1 RIBS.

RELEASED
2010 -03- 12

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	JPH	10.03.04

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED		DRAWING NO. D3916 — REV. A — SHEET 1 OF 4
MFG. APPR.		
APPROVED		TITLE: RIB ASSY, 350 BASKET — SCALE: NTS
DE APPR.		
DATE	10.03.04	

Dart Aerospace Ltd

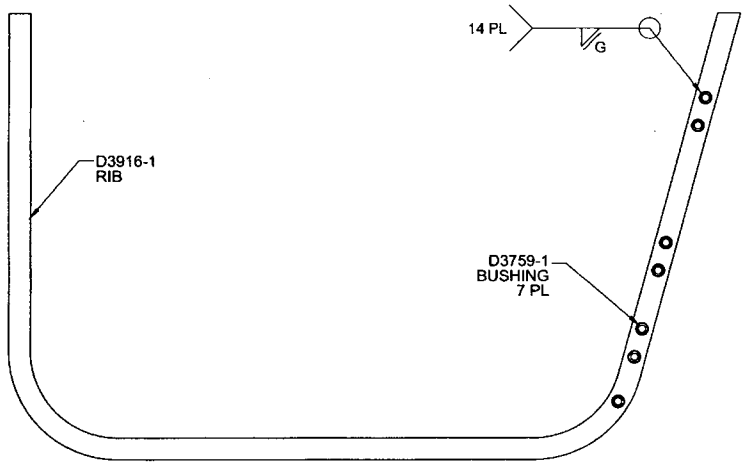
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



w/o 71282

D3916-041 RIB ASSY

RELEASED
2010 -03- 12
AMP

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT -041: 1.84 lbs
8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED		DRAWING NO. D3916 — REV. A — SHEET 2 OF 4
MFG. APPR.		
APPROVED		TITLE: RIB ASSY, 350 BASKET — SCALE: NTS
DE APPR.		
DATE	10.03.04	

Dart Aerospace Ltd

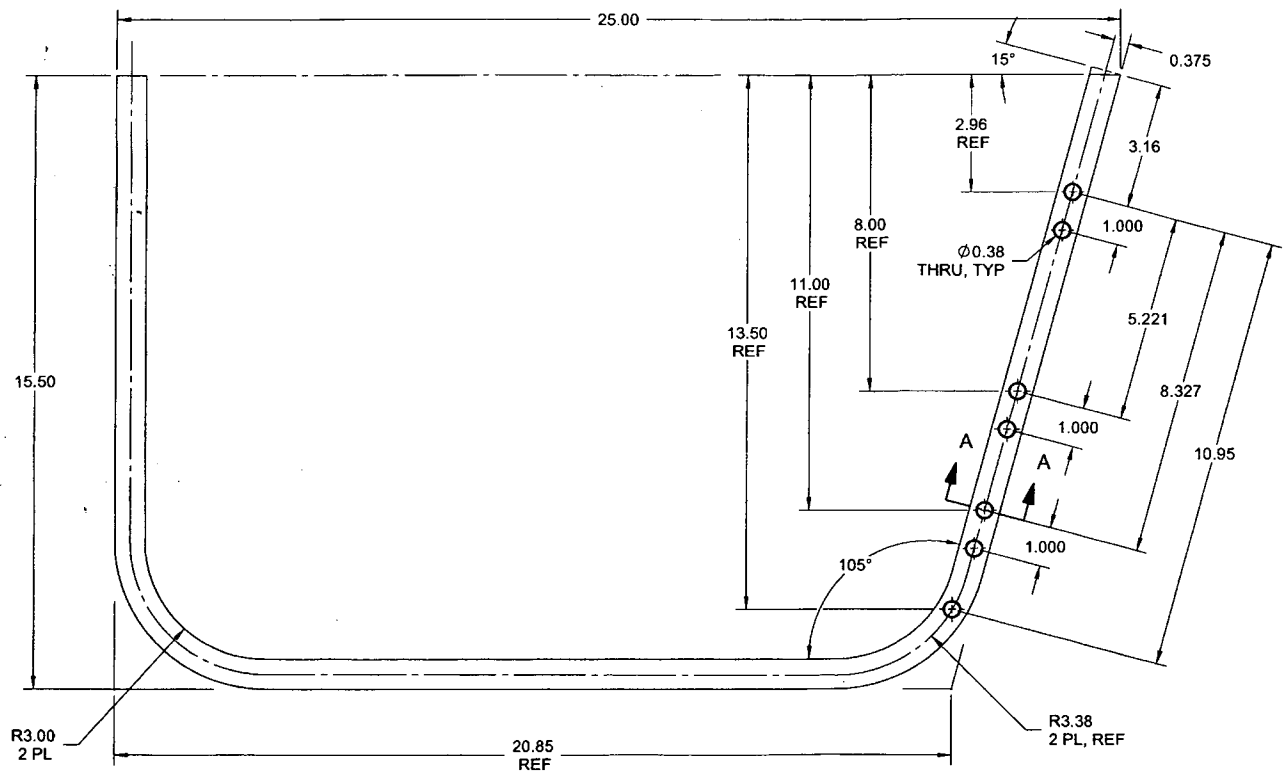
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

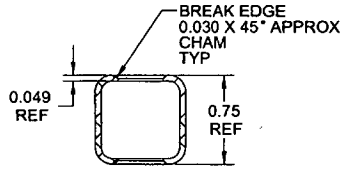
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



9 **D3916-1 RIB**

w/o 71282



SECTION A-A

RELEASED
2010 -03- 12

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.76 lbs
9) TUBE FLAT LENGTH 50.0 REF

DESIGN	AJS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED		DRAWING NO. D3916 — REV. A — SHEET 3 OF 4
MFG. APPR.		
APPROVED		TITLE: RIB ASSY, 350 BASKET — SCALE: NTS
DE APPR.		
DATE	10.03.04	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

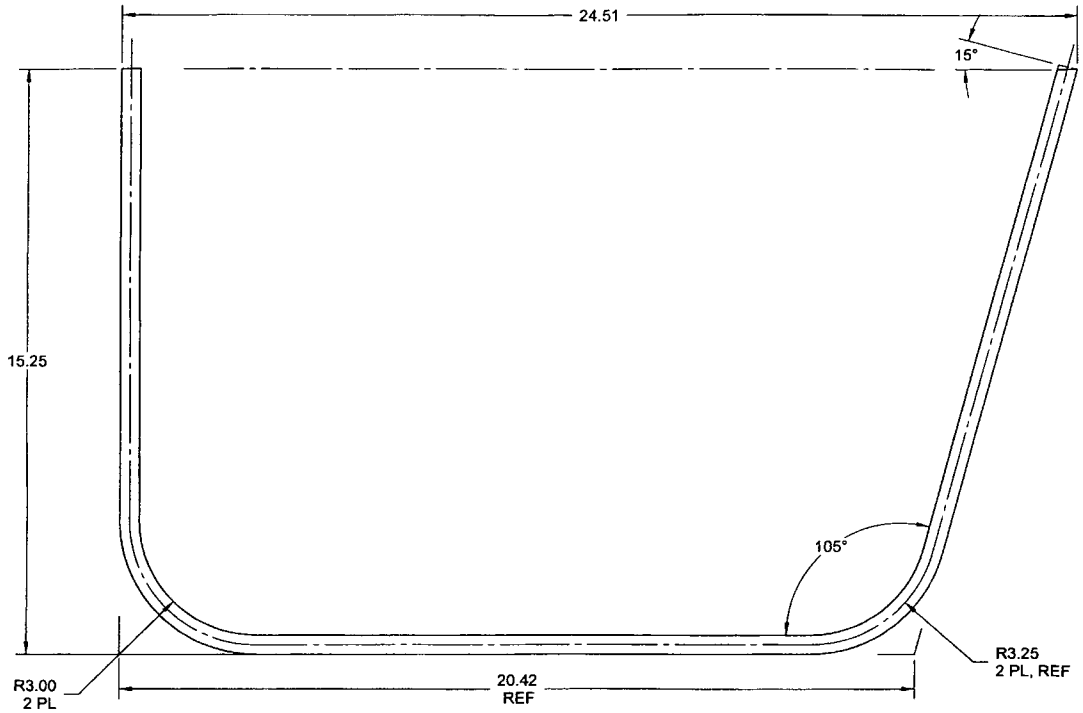
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



9 D3916-5 LIGHT RIB

w671287

RELEASED
2010 -03- 12

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.07 lbs
9) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED		DRAWING NO. D3916 — REV. A — SHEET 4 OF 4
MFG. APPR.		
APPROVED		TITLE: RIB ASSY, 350 BASKET — SCALE: NTS
DE APPR.		
DATE	10.03.04	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries